

Abstract

Page 1

Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Date: 10-7-21

Tooling:

Date:

Run Start




QC:

Date:

SPC (Y/N):

Date:

Stop

| | | | | |
|-----------------|--|--|---|---|
| 100 |  | PURCHASING | 0.00 | |
| Purchasing | | Memo | 0.00 | |
| Purchasing | | Issue P/O: <u>12324</u> | <input type="checkbox"/> Laser cut as per Dwg D2438 | <input type="checkbox"/> Material release |
| | | note is required | | <u>W 10-07-26</u> |
| 110 |  | Receive & Inspect for Damage & Mat'l Certs | 0.00 | |
| Packaging | | Memo | 0.00 | |
| Packaging | | Ensure Material Release Note is attached | | <u>count 10/8/12 SP (206x)</u> |
| 120 |  | QC6- Inspect dimensions to drawing | 0.00 | |
| QC | | Memo | 0.00 | |
| Quality Control | | (6.786" center to center) | | <u>10/10/12 (122)</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 60852

Page 2

Monday, July 26, 2010 10:42:55 AM

Item ID: D2438

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 7/26/2010 Start Qty: 200.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble & Deburr any rough edges

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00

Identify as per dwg & Stock Location: ST456

Packaging

Memo

0.00

Packaging

BB 10/08/18.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 60852

Page 3

Monday, July 26, 2010 10:42:55 AM

Item ID: D2438

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 7/26/2010 Start Qty: 200.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/18 *[Signature]*
MF
10-8-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 10:42:59 AM

Page 1

Work Order ID: 60852



Parent Item: D2438



Parent Item Name: Clamp



Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP: E 05.06.28 Bending removed KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--|--------------|---------------|----------------|--------|
| D2438B  Clamp | | Purchased | No | | | 110 | Each | 0.0000 | 1  | 200 | | 10/8/12 SP | (200) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

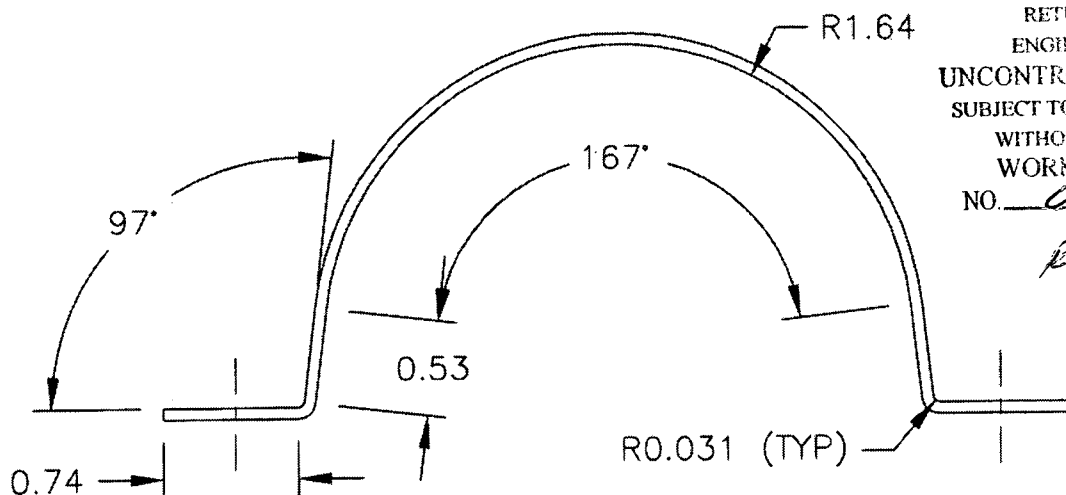
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

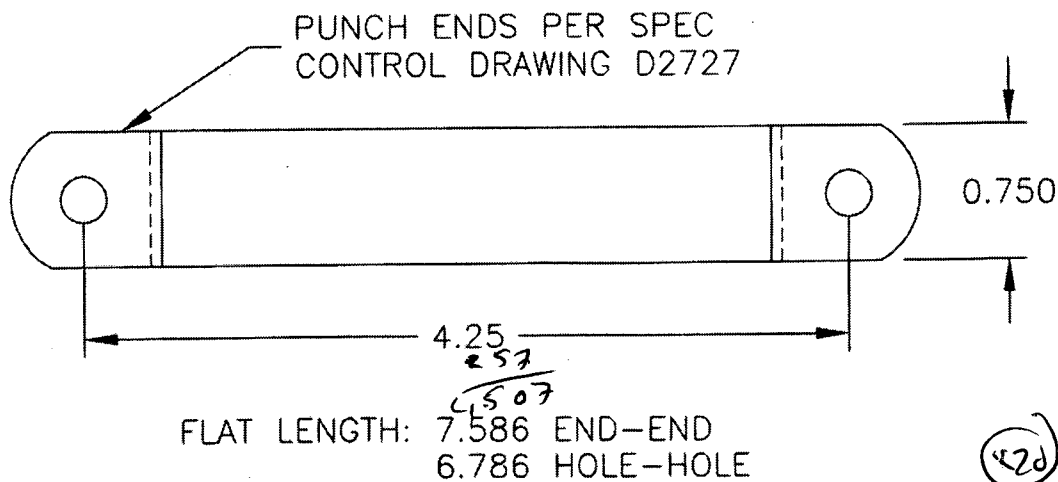


| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>MS</i> | APPROVED <i>MS</i> | DRAWING NO. D2438 | REV. C SHEET 1 OF 1 |
| DATE 98.05.12 | | TITLE CLAMP | SCALE 1:1 |
| A | 96.01.24 | NEW ISSUE | |
| B | 96.05.13 | CHANGE LENGTH | |
| C | 98.05.12 | R1.64 WAS R1.438, CHANGE GEOMETRY | |

RELEASED
49.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60552
210-7-26



MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART
aerospaceDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053**PURCHASE ORDER**Purchase Order ID **PO12324**Purchase Order Date 7/26/10
PO Print Date 7/26/10

Page Number 1 of 1

VC-GFI001

Order From :GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA**FAXED**
JULY 30Contact Name
Vendor Phone 514 630 4877
Vendor Fax 514 630 4849
Vendor Account NbrBuyer
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB**Ship To :** DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|------------------------|----------------------|-----------------------------|---------------|------------|-------------------|
| 1 | D2438B | Clamp | 7/26/10 Yes | 200.00 Each | FedEx Overhgh | \$10.0000 | \$2,000.00 |

Special Inst: PER DRWG D2438 REV.C
CUT & FORMED**PO Total: \$2,000.00****MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 7/26/10



180 AVENUE LABROSSE
POINT-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

| DATE DE LIVRAISON / SHIPPING DATE | | | N° DE BON DE LIVRAISON / SHIPPING MEMO NO. | | PAGE |
|-----------------------------------|-----|-----|--|--|------|
| JR. | MO. | AN. | | | |
| 09 | 08 | 10 | 0443281 | | 1/1 |



VI. NDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

| CODE DE CLIENT CUSTOMER CODE | N° DE CONTRAT JOB NO. | VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO. | EXPÉDIÉ PAR SHIP VIA | | |
|--|--------------------------|---|-------------------------|--|--|
| DART | GFI-0299 | PO12324 | | | |
| QUANTITÉ QUANTITY | N° DE PIÈCE PART NO. | DESCRIPTION | | | |
| 200 | D2438B | CLAMP CUT&FORMED | | | |
| | | CERTIFICATE OF CONFORMANCE REQ | | | |
| MFG. JOB# <u>J0219317-001</u> QTY <u>200</u> | | | | | |
| DH | | | | | |
| | | | | | |

EXPÉDITEUR
SHIPPER

N° DE BON DE LIVRAISON
SHIPPING MEMO NO.



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Solo 1/2

| | | | | | |
|---------------------------|----------------|-----------------------------------|---------------|------------------------------|--------------|
| CERTIFICATE NO. <u>26</u> | | OUR JOB NO <u>J0218317</u> | | SHIPPING MEMO <u>0443281</u> | |
| ITEM | QUANTITY | PURCHASE ORDER | PART NUMBER | REV | NAME |
| | <u>200 PCS</u> | <u>PO12324</u> | <u>D2438B</u> | <u>C</u> | <u>CLAMP</u> |
| MATERIAL | | SUPPLIED BY | | MAT. REL. NO. | |
| <u>S.S.T 304</u> | | <u>TW METALS / NORTH AMERICAN</u> | | <u>4WN7</u> | |

| | PROCESS | PROCESSOR | RELEASE NOTE # |
|---|--|------------|----------------|
| 1 | FIRST ARTICLE INSPECTION REPORT ON FILE | GFI | N/A |
| 2 | REF. GFI MANUFACTURING JOB NUMBER J0218317-001 (200 PCS) | | |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| 6 | | | |
| 7 | | | |
| 8 | | | |
| 9 | | | |

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 10 AUGUST, 2010

G.F.I. Q.C. REP. *[Signature]*



DP12-001 REV 0 Bombardier Certificate of Compliance
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law. Title 18 chapter 47

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME:

GFI, Inc

PURCHASE ORDER No.

0076369

ITEM No.

0001

SHIPPER INVOICE No.

03256240

MATERIAL:

304- s/s Sheet

SPECIFICATION:

-

MANUFACTURING MILL:

North American Stainless

SIZE:

0625

HEAT / LOT No.

4WN7

PART No.

TS06348X96A4

QUANTITY:

2pcs

TEST DEPARTMENT CLERK

Janice Clark

AUTHORITY

8/10/08/10

Joe Schab

Director of Quality Assurance



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 449204 01 Mail To:
FERN STAINLESS PRODUCTS INC.
Customer: 0470 002 P.O. BOX 9001
190 KELLY ROAD
QUAKERTOWN, PA 18951-9001

Ship To:
PERM STAINLESS PRODUCTS INC.
190 KELLY ROAD
QUINCY, MA 01951-9801

Date: 2/02/2009 Page: 1

Stenl: 30d

~~Finish: 20~~

Your Order: 140349

NAS Order: AN 0411727 01

Corrosion: ASTM A262/D2aE, 180D and -OK

PRODUCT DESCRIPTION:

STANDARD STEEL COIL, C.R. ANNEALED & PICKLED; UNS 30400
ASTM A240/08, A80/08, A666/03; ASME SA240/07, SA80/07, SA666/07
CHEM ONLY ON FOLLOWING ASTM: A276/06a, A479/01, A484/06b, A312/07
CHEM ONLY ON FOLLOWING ASME: SA312/07, SA479/07
AMS 5513H HTRK; MIL-S-5059D AMENDS (X CROWN MEAS)
NACE MR0175/01, MR0103/07; Q35760-A X MAG FERR
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; QQS763F Cond A; RoHS Compliant
Material is Free of Radioactive Contamination
IAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001:2000
Melted & Manufactured in the USA; Mat'l is DFARS Compliant

S
10/03/08

| Product ID # | Coil # | Thickness | Width | Weight | -----Length----- | Mark | Pieces |
|--------------|------------|-----------|---------|--------|------------------|------|--------|
| 034NN7 A | * 034WN7 A | .0595 | 48.0000 | 29,060 | COIL 2925.9 | 11 | 1 |

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

| HEAT | CM | C | CO | CR | CU | MN | MO | N | NI | P |
|-------|----|-------|-------|---------|-------|--------|-------|-------|--------|-------|
| 44W17 | US | .0500 | .1025 | 10.3095 | .5550 | 1.7575 | .2970 | .0670 | 0.1365 | .0315 |
| | | S | SI | | | | | | | |
| | | .0014 | .2875 | | | | | | | |

MECHANICAL PROPERTIES

| Product ID # | Coil # | UTS KSI | .2% YS KSI | ELONG %-2" | Hard RB | Tail Hard | A 262 Pr A |
|--------------|--------|------------|---------------|---------------|------------|--------------|---------------|
| 034WN7 A | 034WN7 | F T 99.35 | 54.27 | 44.59 | 89.00 | 84.00 | OK |

TW METALS

TEST FEB 23 2009
ACCEPTED

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

2/02/2009

Certificate of Mill Test Results
SO QTN-86605-001
19Feb09
Pg 1/1

ROSEMARY

PO/RG M49208225

PENN STAINLESS PRODUCTS, INC.

160A 2B FINISH X 48.0000" X 120.0000" L/S
SHEET 304 ANN STAINL
PART NO.

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET
ANNEALED
2B FINISH

SPECIFICATION: MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240

PART NUMBER: M304S|TT GA
|GA|

WHERE "TT" = GAUGE THICKNESS

EG. 16 GAUGE SS SHEET = M304S16GA

GAUGE THICKNESS REFERENCE:

| GAUGE | NOM. THICK. (IN) | THICKNESS RANGE (IN) |
|-------|---------------------|-------------------------|
| 26 | 0.01875 | 0.0178 - 0.019 |
| 25 | 0.021875 | 0.0199 - 0.023 |
| 24 | 0.025 | 0.024 - 0.026 |
| 23 | 0.028125 | 0.027 - 0.029 |
| 22 | 0.03125 | 0.030 - 0.032 |
| 21 | 0.034375 | 0.033 - 0.035 |
| 20 | 0.0375 | 0.036 - 0.040 |
| 19 | 0.04375 | 0.041 - 0.046 |
| 18 | 0.050 | 0.047 - 0.052 |
| 17 | 0.05625 | 0.053 - 0.058 |
| 16 | 0.0625 | 0.059 - 0.065 |
| 15 | 0.0703125 | 0.066 - 0.072 |
| 14 | 0.078125 | 0.073 - 0.083 |
| 13 | 0.09375 | 0.084 - 0.098 |
| 12 | 0.109375 | 0.099 - 0.114 |
| 11 | 0.125 | 0.115 - 0.130 |
| 10 | 0.140625 | 0.131 - 0.145 |
| 9 | 0.15625 | 0.146 - 0.160 |
| 8 | 0.171875 | 0.161 - 0.176 |

REFERENCE ONLY

RELEASED
09/06/23/149

| | | | |
|--|--|------------------------|----------|
| B | REFORMAT DWG, ADD ASTM/ASME SPECS (ZN D8-1), ADD GAUGE REF (C8-1), REF PAR 08-020A | CP | 09.06.01 |
| A | NEW ISSUE | DS | 01.09.24 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.06.01 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. B SHEET 1 OF 1 | |
| DRAWING NO. M304S | | SCALE NTS | |
| TITLE 304/316 SS SHEET | | | |
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